

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017128**Date Inspected:** 08-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang jie / Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

SMAW welding of critical repair weld is identified as 3G-004 of suspender bracket SB020-082 / SB82E. The welder is identified as 062814. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC is appeared to comply with the WPS-345-SMAW-3G(3F)-repair and B-CWR1890.

SMAW welding of critical repair weld is identified as 2G-004 of suspender bracket SB019-074 / SB74E. The welder is identified as 062814. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC is appeared to comply with the WPS-345-SMAW-2G(2F)-repair and B-CWR1889.

BAY#14

FCAW welding of weld joint 1G-001 located on PCMK SEG3013AC of Segment 13AW the welder is identified as 201215. ZPMC QC is identified as Mr. Xia chun hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint 2G-002 located on PCMK KP3004-001 of Segment 13AE the welder is identified as 066236. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

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This QA Inspector observed visual inspection of tack-welds and joint fit up of the weld joint identified as KP3007A-001-004 located on the K-Plate of OBG Segment 13BE. The welder is identified as 046467. The visual inspections of the tack-welds were checked along with ZPMC QC Mr. Wang Xu. The fit-up and tack-welds visually inspected of the aforementioned weld joint appeared to be in general compliance with the applicable contract documents.

BAY#16

SAW welding of weld joint 1G-003 located on PCMK SEG3013AC of Segment 13AW the welder is identified as 045265. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
